

QUALIFICATION REQUIREMENTS

FOR

P/N: 6808893

NSN: 2840-00-830-9342

NOUN: Plate, Rear Carrier Bearing

I. JUSTIFICATION FOR QUALIFICATION REQUIREMENTS

A. Criticality: This item retains the rear carrier bearing in the main diaphragm of the T56 reduction gearbox.

B. Complexity: This item is considered to be complex due to the following materials or manufacturing processes: precision machining, heat treatment, and black oxide treatment

C. Risk: Due to the criticality/complexity described above, pre-award qualification is required to reduce the risk of a part being manufactured that does not meet drawing and functional requirements. To minimize the risk to mission support which could be caused by a first time producer underestimating the complexity described above, demonstration of manufacturing capability must be pre-award.

II. DATA/DOCUMENTATION REQUIREMENTS

All contractors seeking approval to manufacture the subject item must submit the following documentation/certification:

A. Allison drawing 6808893 Revision G or later and all required sub-tier drawings and specifications. Written verification from a Defense Contract Management Area Operations (DCMAO) or another Government representative that the prospective source possesses all required data will suffice. The verification shall be submitted with a list of all required data and the revision of the data in the contractor's possession.

B. Documentation verifying that the potential source has a quality assurance program that meets/exceeds the requirements of ISO 9002 or MIL-I-45208A and paragraphs 5.1, 5.2, 6.1, and 6.2 of MIL-Q-9858A. If the prospective source has previously provided this documentation or has a current contract with SA-ALC/Kelly AFB requiring this level of quality assurance, proof of such will suffice.

C. Identify all processes/inspections which will be performed by subvendors: Identify the vendors and submit proof of their capabilities to perform the processes/inspections indicated. In the event that these subvendors provide the same services to the prime engine manufacturer, it would be desirable to verify this by providing copies of the

appropriate documents or by DCMAO verification. Failure to do so could delay processing of the source approval request.

III. SUBSTANTIATION OF MANUFACTURING CAPABILITY

A. Offerors requesting approval on the basis of previous manufacture of production quantities of the same part for the OEM or an agency of the Department of Defense must submit the following additional documentation/certifications:

1. Evidence or certification that contractor was responsible for the entire manufacture of the item -- i.e., the OEM did not add any value to the item. The actual process sheets and inspection method sheets used to manufacture the item must be submitted for this purpose.

2. Evidence that the item was produced in production quantities, and the items met all requirements and were acceptable to the customer.

3. Evidence that manufacture was recent -- i.e., there have not been any significant changes to the drawing since manufacture and no more than three years have elapsed since last manufacturing the item. No changes shall have occurred in manufacturing methodology, including changes in significant processes or principal parameters of significant processes, process sequence, equipment, tooling design, and processing location.

B. Offerors requesting approval on the basis of previous manufacture of production quantities of a similar aerospace part for the OEM or an agency of the Department of Defense must submit the following additional documentation/certifications:

1. Drawing(s) of similar part(s).

2. Specifications identified on similar part(s) drawing(s) if different than those required by paragraph II.A of this qualification requirement.

3. Evidence to support similarity, to include:

- a. Comparison of manufacturing/inspection processes to show that the similar part includes the full scope of processes required to manufacture the subject item and the processes are of equal or greater complexity and/or difficulty.

- b. Comparison of materials: Material for the similar part must have comparable or more difficult manufacturing characteristics as that for subject part. A material having comparable characteristics is one which the material structure and mechanical properties exhibit a

similar sensitivity to the parameters of all significant processes to be performed on the part.

c. Comparison of functions: Provide a description of the function of the similar part. This must be similar to the function of the subject part.

4. Evidence or certification that contractor was responsible for the entire manufacture of the similar item -- i.e., the OEM did not add any value to the item. Submit the detailed process sheets used to manufacture the similar item(s).

5. Evidence that the similar item was produced in production quantities within the last three years and the end items met all requirements and were acceptable to the customer -- e.g., a contract and shipping document showing part number and/or stock number of part with quantities delivered and accepted.

6. Preliminary process traveler/process summary sheet(s) for the prospective item.

C. Offerors requesting approval on any basis other than III.A or III.B must provide, after confirmation of meeting all requirements of paragraph II:

1. Three (3) sample parts for evaluation along with the actual process sheets used to manufacture the item. A test report documenting conformance to all the requirements of the top drawing, sub-tier drawings, and specifications is required. The contractor must certify that the sample items were manufactured by the perspective source, utilizing the same facilities, manufacturing processes and methods, materials and sub-vendors which will be utilized to produce the item under contract to the Government.

2. The three samples will be evaluated by the Government or an independent laboratory to substantiate the prospective source's ability to successfully manufacture the item. Testing shall consist of an inspection of all three samples for conformance to the drawing noted above, including all drawings and specifications listed thereon. Any significant nonconformance found on any sample is cause for rejection. One or more of the samples may be subjected to destructive examination.

NOTE: Public Law 100-456 was taken into consideration when these Qualification Requirements were written.